

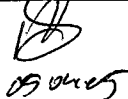
5/08

DART AEROSPACE LTD	Work Order:	22361
Description: Dual Disabling Kit (Light Bell)	Part Number:	D206-739-011 D3370041
Dwg: D3369 Rev. A; D3370 Rev. A	Keyed:	<input type="checkbox"/> Alike <input checked="" type="checkbox"/> Unalike
	Qty:	19 23

Page 1 of 3

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	PK	05.02.07	23																				
2	DC	Photocopy bluefile and create labels per PPP D206-739-011 CHG001	N/A																						
3	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3369-1</td> <td>Battery Lock Body</td> <td></td> </tr> <tr> <td>1</td> <td>D3369-3</td> <td>Cam Lock Shaft</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-1</td> <td>Cam Lock</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3369-1	Battery Lock Body		1	D3369-3	Cam Lock Shaft		1	D3373-1	Cam Lock				
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3369-1	Battery Lock Body																							
1	D3369-3	Cam Lock Shaft																							
1	D3373-1	Cam Lock																							
4	GA	Open D3373-1 lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.																							
5	GA	Using the flat cam, fabricate D3369-5 as per Dwg D3369 Identify as D3369-5																							
6	GA	Assemble D3369-041 as per Dwg D3369. Insert lock body and fasten with lock body nut, then insert lock barrel. Insert D3369-5 fabricated washer and 5/16" SS washer. Thread D3369-3 shaft into lock, then install decal. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3369-5</td> <td>Washer</td> <td></td> </tr> <tr> <td>2</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td></td> </tr> </tbody> </table> Identify as D3369-041 and attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	1	D3369-5	Washer		2	5/16WC	SS Flat Washer												
Qty	Part Number	Description	Batch																						
1	D3369-5	Washer																							
2	5/16WC	SS Flat Washer																							
7	WS	Tack Weld lock shaft to flat cam Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>Steel Rod</td> <td></td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	Steel Rod																
Qty	Part Number	Description	Batch																						
A/R	N/A	Steel Rod																							
8	FP	Powder Coat Fire Red (Ref. 4.3.5.10) as per QSI 005 4.3 Mask Dowel Pins Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3370-1</td> <td>Pedal Lock Base</td> <td>B 22285</td> </tr> <tr> <td>1</td> <td>D3370-3</td> <td>Pedal Lock Cover</td> <td>B 22286</td> </tr> <tr> <td>1</td> <td>D3385-1</td> <td>Hinge</td> <td>B 22271</td> </tr> </tbody> </table> Identify as D3370-051	Qty	Part Number	Description	Batch	1	D3370-1	Pedal Lock Base	B 22285	1	D3370-3	Pedal Lock Cover	B 22286	1	D3385-1	Hinge	B 22271							
Qty	Part Number	Description	Batch																						
1	D3370-1	Pedal Lock Base	B 22285																						
1	D3370-3	Pedal Lock Cover	B 22286																						
1	D3385-1	Hinge	B 22271																						
9	QC3	Inspect Powder Coat	SB	05/03/21	19																				
10	GA	Press dowel pins into D3370-3 pedal lock cover, then assemble hinge as per Dwg D3370 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D2728-7</td> <td>Decal</td> <td></td> </tr> <tr> <td>1</td> <td>D3373-5</td> <td>Cam Lock B 22659</td> <td>B 22383</td> </tr> <tr> <td>4</td> <td>AN526C832R6</td> <td>Screw</td> <td>M 16612</td> </tr> <tr> <td>32</td> <td>N/A 238-028</td> <td>Ø3/16" Dowel Pin 1/2" long</td> <td>M 16798</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D2728-7	Decal		1	D3373-5	Cam Lock B 22659	B 22383	4	AN526C832R6	Screw	M 16612	32	N/A 238-028	Ø3/16" Dowel Pin 1/2" long	M 16798	SB	05/03/21	19
Qty	Part Number	Description	Batch																						
1	D2728-7	Decal																							
1	D3373-5	Cam Lock B 22659	B 22383																						
4	AN526C832R6	Screw	M 16612																						
32	N/A 238-028	Ø3/16" Dowel Pin 1/2" long	M 16798																						
11	GA	Open D3373-5 lock package. Keep keys, lock body, lock body nut, screw, offset cam and lock barrel. Discard the rest.	SB	05/02/14	19																				
12	GA	Fabricate D3373-5 Cam Lock as per Dwg D3370 Identify as D3373-5	SB	05/03/21	19																				

RELEASED
21/05-01-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector
05.02.14	10	ADD LOCK-TITE TO LOCK 7/8 NUT	RF	05.04.13	N/A	RF 05.02.14	 05.04.13

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22361
Description: Dual Disabling Kit (Light Bell)		Part Number:	D206-739-011
		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3369 Rev. A; D3370 Rev. A		Qty:	23
Page 2 of 3			

Step	Location	Procedure	By	Date	Qty																
13	GA	Assemble lock mechanism and cam and install decal as per Dwg D3370	SB	05/03/21	19																
14	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3384-1</td><td>Cyclic Sock</td><td>B 22282</td></tr><tr><td>2</td><td>CBL-460</td><td>Loop Sleeve</td><td>M 16713</td></tr><tr><td>24</td><td>CBL-1240</td><td>Cable</td><td>M 16713</td></tr></table> Identify as D3384-041	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock	B 22282	2	CBL-460	Loop Sleeve	M 16713	24	CBL-1240	Cable	M 16713	SB	05/03/21	19
Qty	Part Number	Description	Batch																		
1	D3384-1	Cyclic Sock	B 22282																		
2	CBL-460	Loop Sleeve	M 16713																		
24	CBL-1240	Cable	M 16713																		
15	GA	Assemble D3384-041 to D3370-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3370. Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN960-416</td><td>Washer</td><td>M 5519</td></tr><tr><td>1</td><td>HX-81</td><td>1/4"-20 SHCS 3/8" long</td><td>M 16971</td></tr></table> Identify as D3370-041 & attach keys Record the Key Number on page 3	Qty	Part Number	Description	Batch	2	AN960-416	Washer	M 5519	1	HX-81	1/4"-20 SHCS 3/8" long	M 16971	SB	05/03/21	19				
Qty	Part Number	Description	Batch																		
2	AN960-416	Washer	M 5519																		
1	HX-81	1/4"-20 SHCS 3/8" long	M 16971																		
16	QC5	Inspect work to Step 15	UC	05-03-21	19																
17	PK	Ensure that keys are attached to D3369-041 and D3370-041 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3369-041</td><td>Battery Lock Assembly</td><td></td></tr><tr><td>1</td><td>D3370-041</td><td>Pedal Lock Assembly</td><td>B 22361</td></tr></table> Ensure that keys can be locked and unlocked for each D3369-041 and D3370-041 assembly.	Qty	Part Number	Description	Batch	1	D3369-041	Battery Lock Assembly		1	D3370-041	Pedal Lock Assembly	B 22361	CL	05/03/23	19				
Qty	Part Number	Description	Batch																		
1	D3369-041	Battery Lock Assembly																			
1	D3370-041	Pedal Lock Assembly	B 22361																		
18	QC4	Inspect Kit 100% for Completeness on the W/O N/A W																			
19	PK	Identify and pack for shipping as per PPP D206-739-011 IDENTIFY & STOCK	CL	05/03/23	19																
20	AC	Cost / part: 23.62	JAC	05-03-29	19																
21	DC	Close W/O 22.44 Inspect Level 21	KA	05.04.05	19																

RELEASED
 05-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

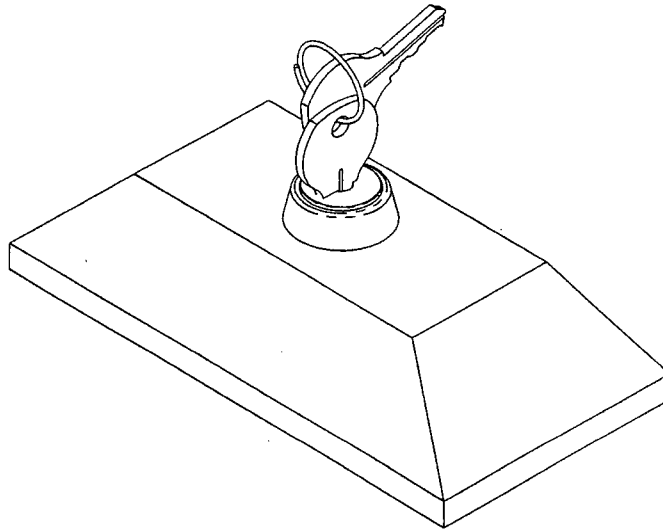
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NOTE: Date & initial all entries

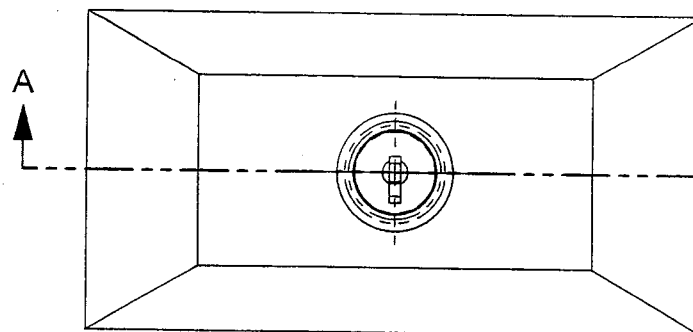
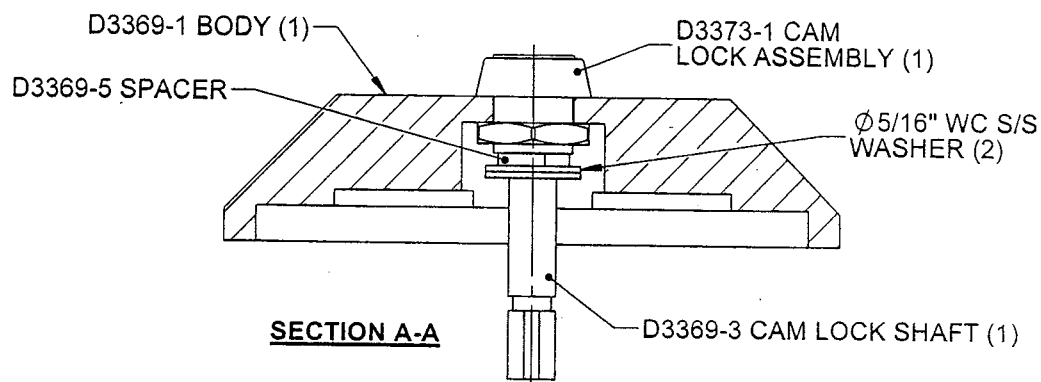
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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3369	REV. A SHEET 1 OF 4
DATE 04.12.16	TITLE BATTERY LOCK		SCALE 1:1.5
A	04.12.16	NEW ISSUE	



DETAIL B: (BATTERY LOCK SHOWN LOCKED WITH KEY)



D3369-051 BATTERY LOCK ASSEMBLY

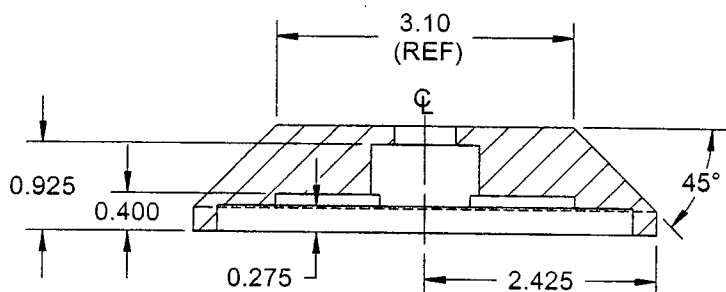
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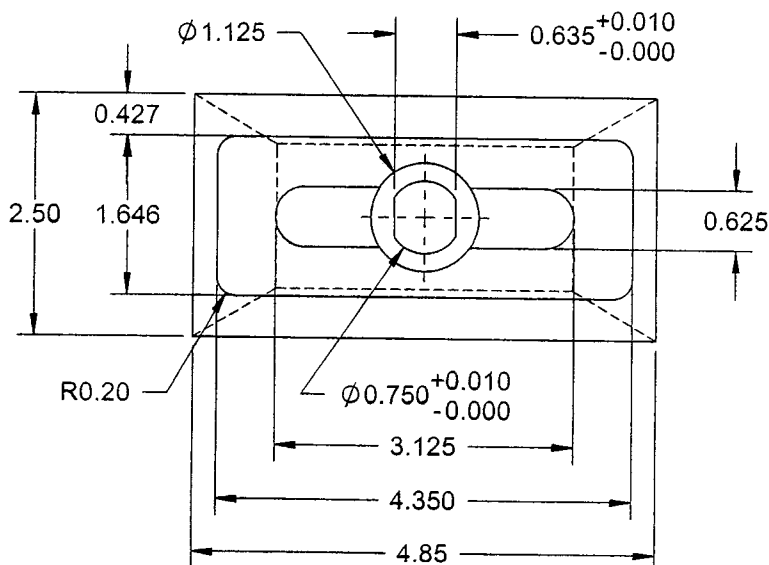
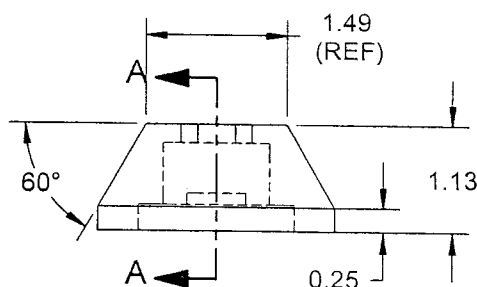
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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 1:2



SECTION A-A



D3369-1 BODY

NOTES:

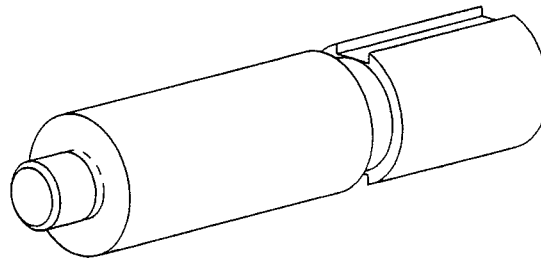
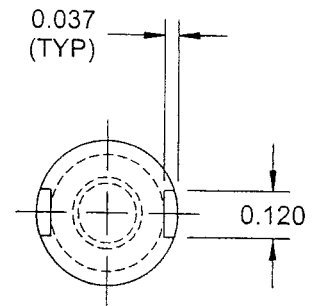
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1



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NOTES:

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

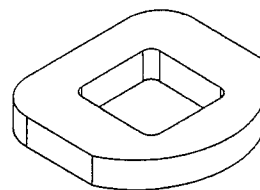
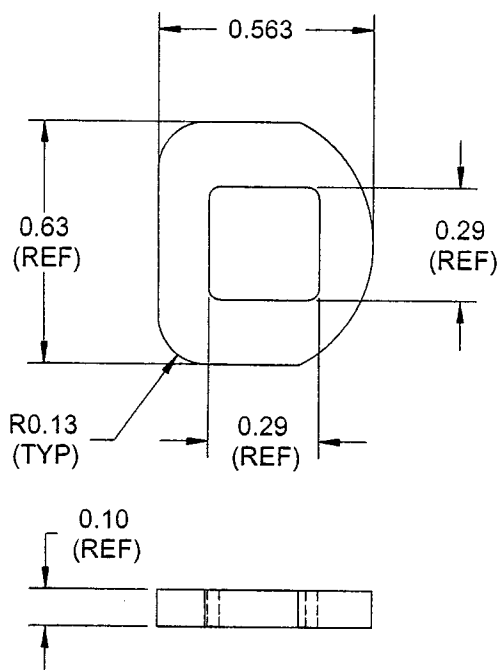
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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DATE 04.12.16		TITLE BATTERY LOCK	SCALE 2:1

SPECIFICATION CONTROL DRAWING



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D3369-5 SPACER

WORK ORDER
NO. 2236

NOTES:

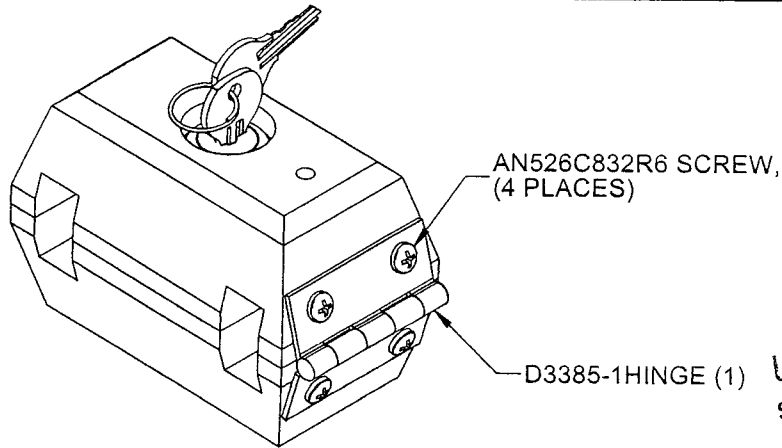
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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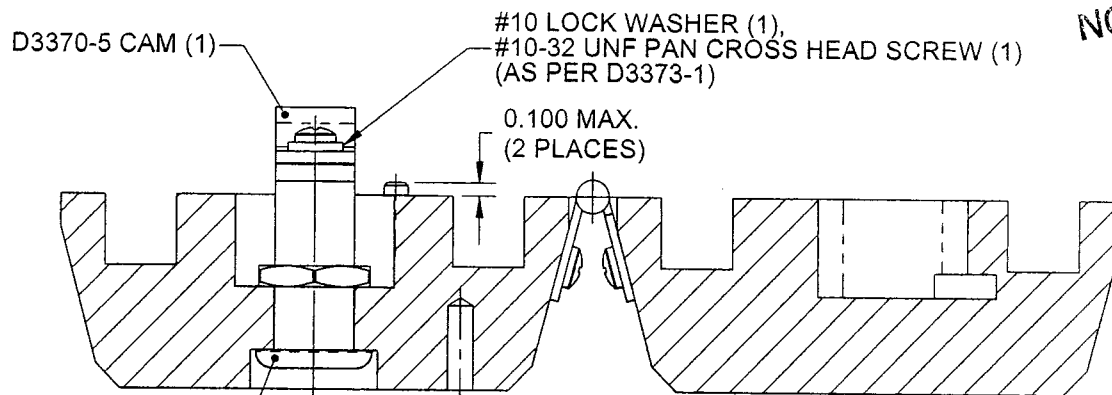
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CHECKED	APPROVED	DRAWING NO. D3370	REV. A SHEET 1 OF 4
DATE 04.12.15	TITLE PEDAL LOCK		SCALE 1:1.5
A	04.12.15	NEW ISSUE	



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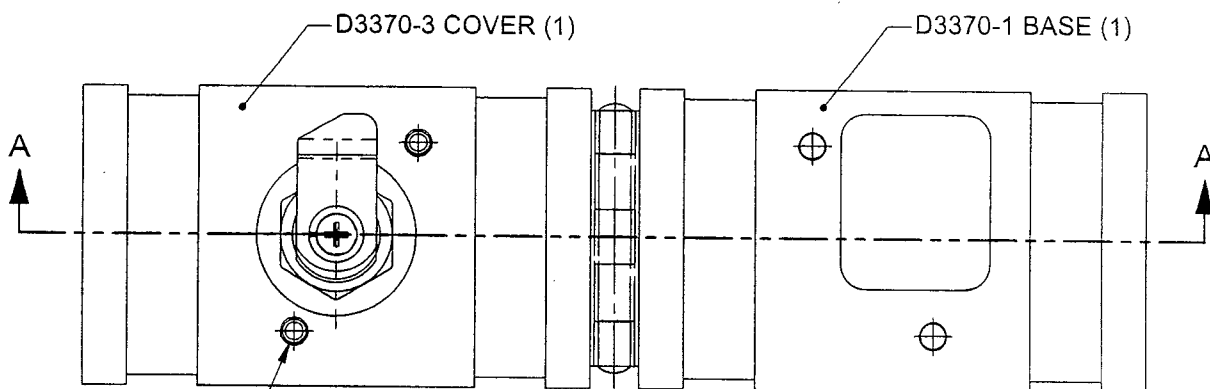
WORK ORDER
NO. 22361

DETAIL B: (PEDAL LOCK SHOWN LOCKED WITH KEY)



D3373-5 CAM
LOCK ASS'Y (1)

SECTION A-A



STD. GROUND
DOWEL PIN
Ø3/16 x 0.50
(2 PLACES)

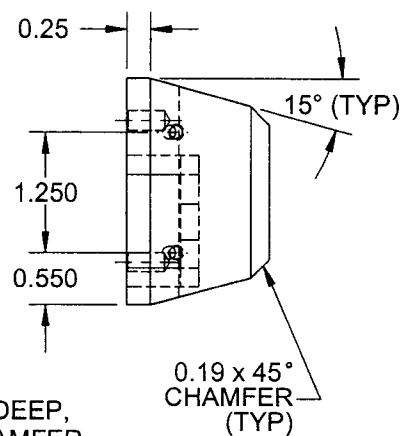
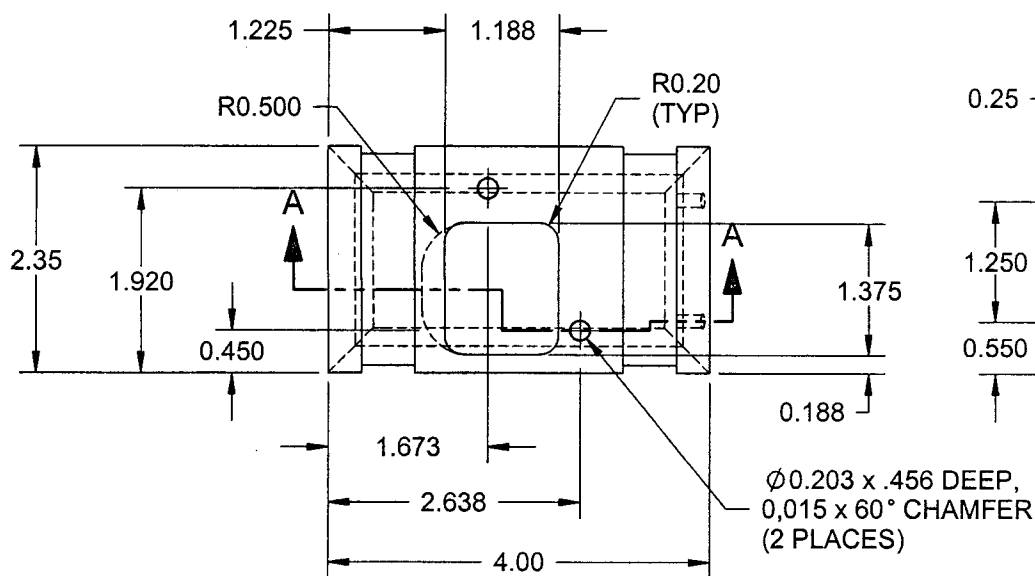
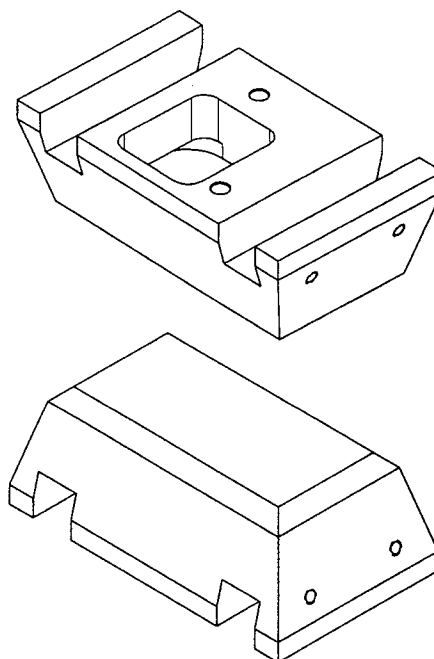
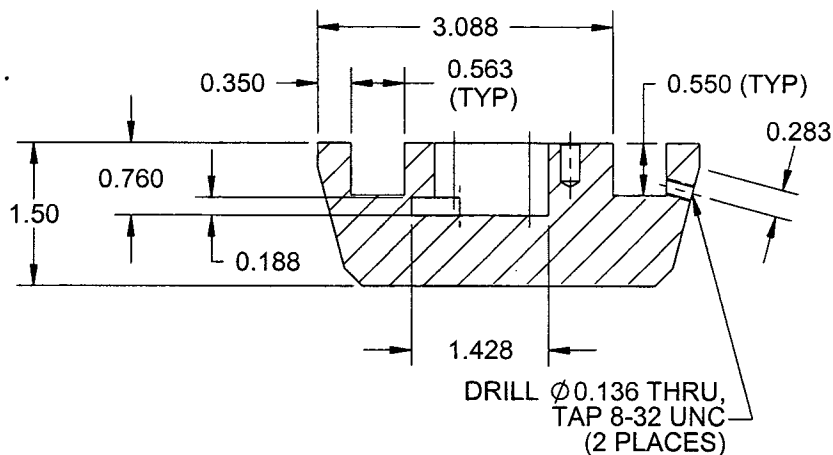
D3370-051 PEDAL LOCK ASSEMBLY

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PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3370	REV. A SHEET 2 OF 4
DATE 04.12.15	TITLE PÉDAL LOCK		SCALE 1:2



D3370-1 BASE

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

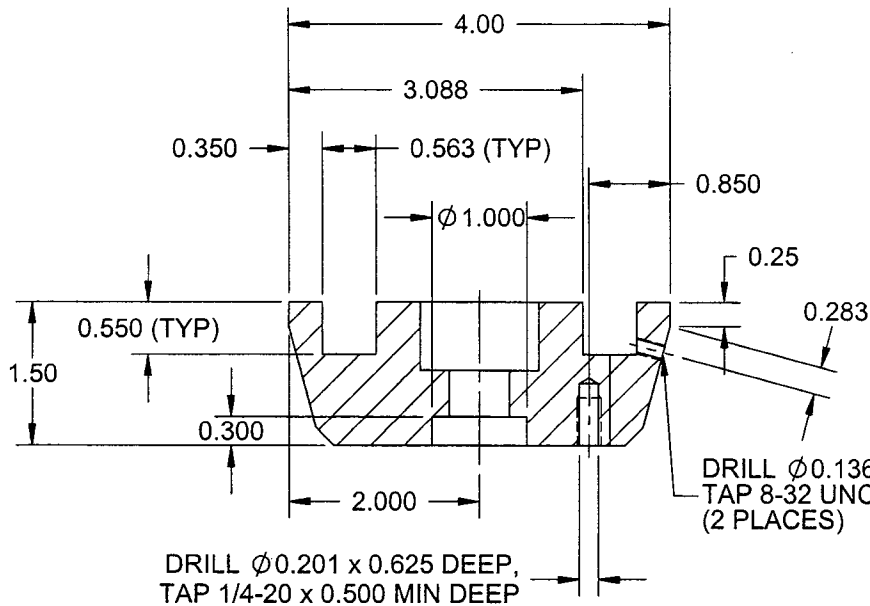
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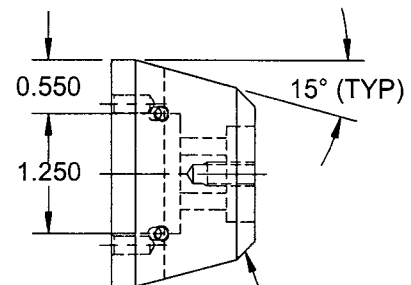
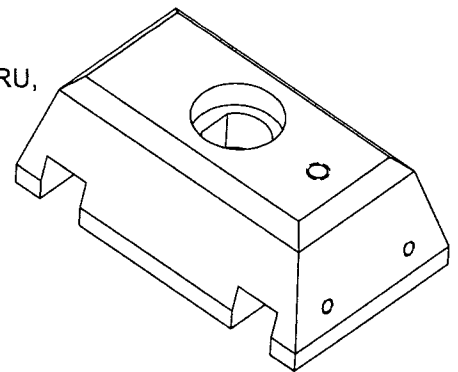
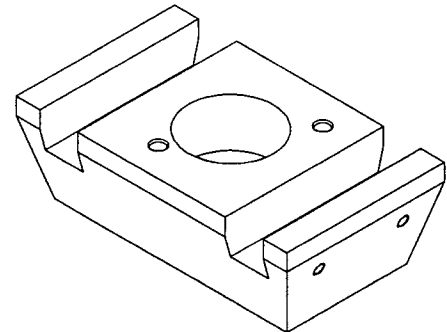
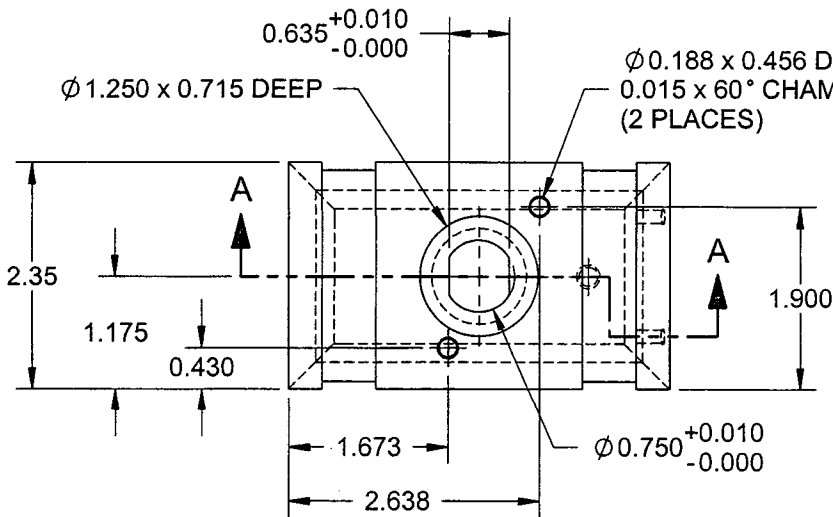
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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3370	REV. A SHEET 3 OF 4
DATE 04.12.15		TITLE PEDAL LOCK	SCALE 1:2



SECTION A-A



0.19 x 45°
CHAMFER
(TYP)

D3370-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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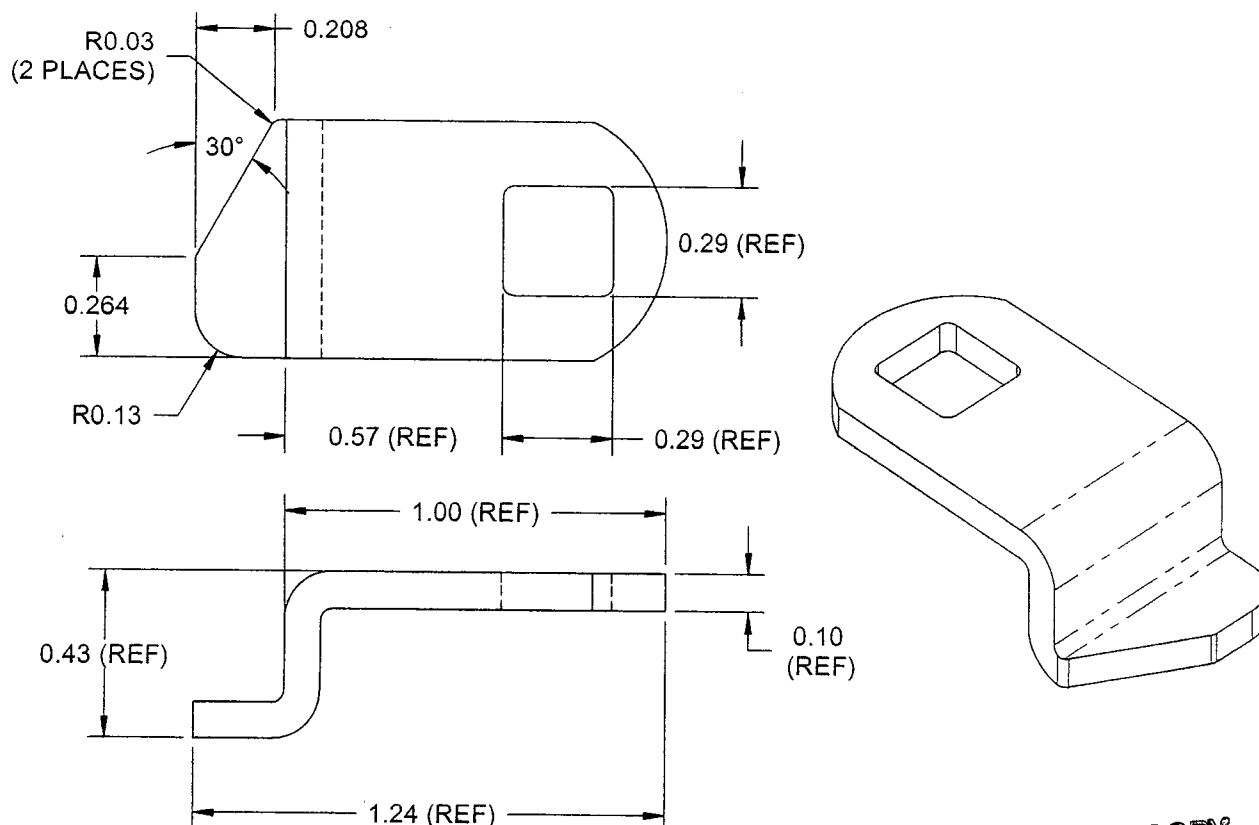
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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3370	REV. A SHEET 4 OF 4
DATE 04.12.16	TITLE PEDAL LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



D3370-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 22361

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Feb 07, 2005
12:33 pm

Work Order No : 0022361
Project Name : D206-739-011
Project For : WK508
Work Order Type : Main
Main WO Number :
House Part Number : *D206-739-011
Description : Dual Disabling Kit
Manufactured : Yes
Amount Req'd : 23
Amount Done : 0
Start Date : 02-07-05
Est Finish Date : 02-16-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00